

HS 897 - ADHESIVE STANDARD

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REVISION LOG

Rev	Remarks
0	Original Issue
1	Added Loctite 668 per SR 60966

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	Revision Level - 1 - PUBLISHED	Security Level - PUBLIC	Standard No. HS 897

1 PURPOSE

This standard contains a list of approved adhesives, thread lockers & retaining compounds for use in Husky systems. Specific product selection is the responsibility of the equipment operator/owner and may depend on climate, application, performance and regional/regulatory requirements.

2 DOCUMENT CONTROL

Revisions to this document shall be authorized by Corporate Operations.

3 REFERENCES

HS 252 – Standard Assembly Torques

HS 609 – Lubricants and Coolants

4 ADHESIVES

4.1 USAGE

- Clean threads of machine oils and lubricant to maximize bonding of adhesive.
- For thru holes, apply the adhesive onto the bolt at the thread engagement area.
- For blind holes, apply the adhesive to the fastener and the internal threads down to the bottom of the hole. If the adhesive is only applied to the fastener, air pressure will force the liquid thread locker to escape as you torque down.
- For disassembly: Remove with standard hand tools or in rare instances where hand tools do not work because of excessive engagement length, apply localized heat to nut or bolt to approximately 250°C. Disassemble while hot.

4.2 SELECTION

Table 1 - Adhesive Selection for Specific Applications

Application			Food Grade	Non-Food Grade
Cam followers, set screw threads, screws that secure the hot runner manifold (Not required when Nylock coated bolts are used)			Not Available	Loctite 248 Loctite 242
Screws installed into the hot runner manifold (heads & threads for: Sprue Bushing screws, Sprue Bar screws, Transfer Bushing screws, Backup Insulator screws, T/C mounting screws)			See HS 609 – Lubricants and Coolants	
FITTING LUBRICATION	STEEL	NPT	Loctite 567	Loctite 577
AIR	STEEL, ALU and BRASS	NPT		
WATER	STEEL and BRASS	NPT		
	ALUMINUM	NPT		
ULTRASYN & ULTRASHOT GUIDE ELEMENTS	STEEL	TRANSITIONAL FIT	Not Available	Loctite 603 (USync E & Ultrashot))
				Loctite 668 (USync P & H)

Table 2 - Adhesive Selection for General Applications


Application		Connection				Product Name	Other Notes
MECHANICAL	ACTIVE METALS	Fasteners M5 and smaller	Removable with hand tools	Low Strength	-55 to 150 Degrees C	Loctite 222 (purple)	
		Fasteners M6 to M20	Removable with hand tools	Medium Strength	-54 to 149 Degrees C	Loctite 242 (blue)	
		Fasteners M6 to M20	Removable with hand tools	Medium Strength	-54 to 149 Degrees C	Loctite 243 (blue)	Faster cure time and better oil resistance than with Loctite 242
		Fasteners M10 to M25 (or greater)	Removable with heat and hand tools	High Strength	-54 to 150 Degrees C	Loctite 271 (red)	
	INACTIVE METALS*	Fasteners M6 to M20	Removable with heat and hand tools	Medium Strength	-54 to 149 Degrees C	Loctite 2440**	
		Fasteners M10 to M25 (or greater)	Removable with heat and hand tools	High Strength	-54 to 149 Degrees C	Loctite 2760**	

* Inactive metals include stainless steel, zinc, magnesium, black oxide, cadmium, anodized aluminum, passivated titanium, etc.

** 2440 and 2760 are primerless thread locking adhesives designed for use with most inactive metals except anodized aluminum.

Note – The use of Loctite 222, 242, 243 and 271 without the use of a primer on inactive metal threads results in lower bond strengths as well as significantly increased cure times.

Table 3 - Adhesive List

Product	Manufacturer	Name	Product Use
	LOCTITE®	Loctite 567	General purpose instant sealer for tapered and straight/tapered fittings Food grade
	LOCTITE®	Loctite 577	Designed for the locking and sealing of metal threaded pipes and fittings. Particularly suitable for use on stainless steel without the need for surface activation Non-food grade
	LOCTITE®	Loctite 222	Low Strength Viscosity Low, thixotropic General purpose thread locker Breakaway torque 6Nm (M10) Color: Purple Liquid form
	LOCTITE®	Loctite 242	Medium strength Medium viscosity General purpose thread locker Breakaway torque 12Nm (M10) Color: Blue Liquid form
	LOCTITE®	Loctite 243	Medium strength Medium viscosity General purpose thread locker Breakaway torque 20Nm (M10) Color: Blue Liquid form
	LOCTITE®	Loctite 271	High strength Low viscosity General purpose thread locker Breakaway torque 28.5Nm (M10) Color: Red Liquid form

		<p>Loctite 2440 DISCONTINUED → Replace w/ Loctite 243</p>	<p>Medium strength Medium viscosity General purpose thread locker Breakaway torque 24Nm (M10) Color: Blue Liquid form Primerless</p>
		<p>Loctite 2760</p>	<p>High strength Medium viscosity General purpose thread locker Breakaway torque 37Nm (M10) Color: Red Liquid form Primerless</p>
		<p>Loctite 248</p>	<p>Medium strength Medium viscosity General purpose thread locker Breakaway torque 12Nm (M10) Color: Blue Convenient stick format prevents dripping</p>
		<p>Loctite 603</p>	<p>Retaining Compound High strength. Ideal for bearings. For use on close-fitting cylindrical parts. High oil tolerance</p>
		<p>Loctite 668</p>	<p>Retaining Compound Medium to High strength. For use on close-fitting cylindrical parts. Very high oil tolerance Wax/solid form stick to prevent dripping</p>

5 LINKS

[Loctite Safety Data Sheets](#)